



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.8511

Job Sheet 178046



Part No: 647.8511

Job Qty: 4 ea

Part Name: Insert



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/25/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 16-11-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/31/18	0.00	0.00	Start Up Machining-1		
100	Doosan	4 pcs		5/31/18	0.00	3.19	Doosan		
110	QC	4 pcs		5/31/18	0.00	0.00	QC2 Machining-1		
120	QC	4 pcs		5/31/18	0.00	0.00	QC8 Machining-1		
122	Outsource	4 pcs		5/31/18			GRO002-VC	7	
123	Packaging	4 pcs		5/31/18	0.00	0.00	Packaging2		
124	QC	4 pcs		5/31/18	0.00	0.00	QC2		
130	Packaging	4 pcs		5/31/18	0.00	0.00	Packaging3-1		
140	QC21-SA	4 Ea		5/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FB511 & Dwg 647.8500 Folio Rev: AA Dwg Rev: N/C 2-Deburr
Descriptions: 122 - Issue P/O to Groupe Altech: P/O 040319 - Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required
130 - LOCATION: WA001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.625	303 Round Bar 0.625"	.1600 ft (.04 ea)	90-Start up Operation	5053646

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.625	0	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Insert	0.016Inches $\pm$ 0.005	0.021 0.011		
2	Insert	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
3	Insert	0.020Inches $\pm$ 0.010	0.030 0.010	Radius	
4	Insert	0.210Inches $\pm$ 0.005 - 0.001	0.215 0.209	Diameter	
5	Insert	0.300Inches $\pm$ 0.010	0.310	Diameter	

				0.290	
6	Insert	0.350	0.350Inches ± 0.010	0.360 0.340	Diameter
7	Insert	0.058	0.060Inches ± 0.005	0.065 0.055	
8	Insert	0.375	0.374Inches ± 0.005	0.379 0.369	
9	Insert	0.555	0.560Inches $+ 0.000$ $- 0.010$	0.560 0.550	
10	Insert	0.367	0.367Inches ± 0.005	0.372 0.362	
11	Insert	0.094	0.097Inches ± 0.005	0.102 0.092	Diameter
12	Insert	0.080	0.075Inches ± 0.005	0.080 0.070	Depth

Plex 5/25/18 12:35 PM Dart.lajeunesse.marie

OTHER:



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040319**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040319
PO Date: 6/26/18
Due Date: 6/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178046	647.8511	Insert -Issue P/O to Groupe Altech: P/O _____ -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	6/29/18	4 pcs	0 pcs	4 pcs	\$1.41162059/pcs	\$5.65
Line Item Note ** rush - need back asap **										
2	175623	C3-8-5	Solenoid Cover -Issue P/O to GROUPE ALTECH: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/29/18	20 pcs	0 pcs	20 pcs	\$3.08647059/pcs	\$61.73
3	178948	TM3039G001	Draining Tool -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/29/18	10 pcs	0 pcs	10 pcs	\$2.82330059/pcs	\$28.23

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	173883	RBE703A95-0505-00-1	Quill -Issue P/O to Groupe Altech: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95- 0505-00-1 Rev. 9 -Certificate of Conformity is required	Firmed	6/29/18	10 pcs	0 pcs	10 pcs	\$10.8055606/pcs	\$108.06
5	179351	RBT18649-13	Main Rotor Hub Work Aid Item #13 -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/29/18	11 pcs	0 pcs	11 pcs	\$3.66647059/pcs	\$40.33
6	179164	646.3910	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	6/29/18	30 pcs	0 pcs	30 pcs	\$4.16/pcs	\$124.80
7	179165	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	6/29/18	20 pcs	0 pcs	20 pcs	\$4.16/pcs	\$83.20
8	177368	SK145-0115-20	Clamp Bar ISSUE P/O: _____ PASSIVATE AS PER DWG ACCORDANCE WITH ASTM A967 C OF C IS REQUIRED	Firmed	6/29/18	22 pcs	0 pcs	22 pcs	\$1.80647059/pcs	\$39.74
9	178824	RBW6505G00831-3G-7	Swivel Plate Weldment -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; A36 -Certificate of Conformity is required	Firmed	6/29/18	1 pcs	0 pcs	1 pcs	\$104.896471/pcs	\$104.90
Line Item Note ** Rush - need back by Friday 6/29 **										
10	177859	RBW6505G00831-3G-1	Leg Assembly Weldment -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; A36 -Certificate of Conformity is required	Firmed	6/29/18	1 pcs	0 pcs	1 pcs	\$104.896471/pcs	\$104.90
Line Item Note ** Rush - need back by Friday 6/29 **										

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	178044	647.8510	Insert ISSUE PO: _____ SUPPLIER: GROUPE ALTECH -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	6/29/18	40 pcs	0 pcs	40 pcs	\$1.41162059/pcs	\$56.46
Line Item Note ** need back asap **										
Grand Total:										\$758.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CT.

Plex 6/27/18 2:34 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(010576-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010576- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Jun-2018		Jessie Boisvert		040319				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.8511 Rev.	647.8511 PASSIVATE MIL-S-5002 TYPE 6	PASSIVATION CH	4	4	0	0	0
8	SK145-0115-20 Rev.	SK145-0115-20 01 -PASSIVATION- #3 [PASSIVATION #3] SPÉC: ASTM A967 C OF C *** SPÉC: AS PER DRAWING ***	PASSIVATION CH	22	22 ✓	0	0	0
11	647.8510 Rev.	647.8510 PASSIVATE ,MIL-S-5002 TYPE 6 TRY 1 PART FIRST	PASSIVATION CH	40	40	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

P

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.